

Work Order ID 75395

75395

Page 1

October-21-11 11:32:20 AM

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 21/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/10/21 Tooling: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3804	A								
IIN-D206-642	O								

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

SCRAP

Scrap

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75395***75395***

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Item ID: D206-642-151

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 21/10/2011 Start Qty: 1.00

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Required Date: 02/11/2011 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M117884/M118735

BE 11-11-14

4-Grind weld flush to cap on top surface only.

BE 11-11-14

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

SAD 11-11-14

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

{ OK 11/11/14

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

next Page

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-151 PAR #: _____ Fault Category: Leading Edge / NCR: Yes (No) DQA: W Date: 11/12/06
11-1022 Resolution: Re work Disposition: Re work QA: N/C Closed: (K) Date: 11/12/06

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/11/15</u>	<u>100-11</u>	<u>Qty of Ground handling level holes is oversized + elongated. R.C. Process. Drilling through. AL to Stanley.</u>	<u>CP</u> <u>11.11.15</u> <u>PS/042</u>	<u>Fill hole in with weld AS PER Q57004 AIR M117884</u>	<u>BE</u> <u>11-11-15</u> <u>BE</u> <u>11-11-15</u>	<u>DP</u> <u>11-11-15</u>	<u>CP</u> <u>11.11.15</u> <u>PS/042</u>	<u>S</u> <u>11/11/15</u>
				<u>ReDrill as Per Dwg.</u>	<u>DC</u> <u>11/11/15</u>	<u>DP</u> <u>11-11-15</u>	<u>CP</u> <u>11.11.15</u>	<u>S</u> <u>11/11/15</u>

NOTE: Date & initial all entries

Work Order ID 75395

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October-21-11 11:32:20 AM

Item ID: D206-642-151

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 21/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

W/O: 15395		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-151 PAR #: _____ Fault Category: Skid-tube NCR: Yes No DQA: u Date: 11/12/06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: 11-1022		WORK ORDER NON-CONFORMANCE (NCR) # 1669.24						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/16/25	#110	Found qty x4 more bbs with weeping weld repair all in same area <u>EQUIP.</u> Scrap tube. <u>EL Pass</u>	u 11/11/25	Scrap & Destroy tube.	B 11/11/25	S 11/11/25	u 11/11/25	S 11/11/25
		Started with qty 1 at step 100						

NOTE: Date & initial all entries

Work Order ID 75395

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Item ID: D206-642-151 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube
 Start Date: 21/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170 QC6- Inspect dimensions to drawing 0.00

170

QC

Quality Control

Memo

180

180

Skidtubes

Skidtubes

Skidtubes

Memo

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: _____ Time: _____

Finish Date: _____ Time: _____

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 _____

Sikaflex expire date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75395

October-21-11 11:32:20 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 21/10/2011 **Start Qty:** 1.00

1

Required Date: 02/11/2011 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 75395***75395***

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October-21-11 11:32:20 AM

Item ID: D206-642-151 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube
Start Date: 21/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 02/11/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

0.00

Skidtubes

Memo

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod _____

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod _____

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75395

October-21-11 11:32:20 AM

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 21/10/2011 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 02/11/2011 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230	QC5- Inspect part completeness to step on W/O	0.00
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230

QC	Memo	0.00
----	------	------

Quality Control

240	Pressure Wash per QSI005 4.3	0.00
-----	------------------------------	------

240

HandFinish	Memo	0.00
------------	------	------

Hand Finishing

250	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00
-----	--	------

250

Powdercoat	Memo	0.00
------------	------	------

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75395

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 21/10/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 02/11/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260 QC3- Inspect Part Finish

0.00

260

0.00

QC Memo
Quality Control

270	0.00
-----	------

270

HandFinishing

0.00

HandFinish Memo

Hand Finishing I-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Quality Control

W/O:		WORK ORDER CHANGES					
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Work Order ID 75395***75395***

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Item ID: D206-642-151

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 21/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC5- Inspect part completeness to step on W/O	0.00							
300									
QC	Memo	0.00							
Quality Control									
310	Packaging	0.00							
310									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-151 Location: _____ PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

21-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75395

75395

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC IPP
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620		Manufactured	No			110	Each	13.0000	1	1			

D2620

Skidtube, 206 Skidtube

**

Location	Loc Qty	Loc Code
LG	13	①
71616	3	
71617	6	
73783	1	
73785	1	
73786	2	

D2647

Manufactured No

110

Each

199.0000

1

1

D2647

Cap

**

30-11-14

Location	Loc Qty	Loc Code
LG002	199	
55352	4	
71171	11	
73826	184	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

18,966.00

52

52

CR3212-4-04

Cherry Rivet

Location

Loc Qty

Loc Code

ST311

150

116471

78

117816

3

118686

1

118840

68

st510

10000

119075

10000

ST516

8816

119017

8816

D2654-1

Manufactured

No

180

Each

4.0000

1

1

D2654-1

Web

Location

Loc Qty

Loc Code

LG

4

73794

4

D3286-1

Manufactured

No

180

Each

110.0000

2

2

D3286-1

Doubler

Location

Loc Qty

Loc Code

LG002

110

74111

22

74441

88

74872

2

u/11/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75395

75395

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 200 Each 1,184.000 19 19

D2649******

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	617	
68224	2	
71355	2	
72704	2	
72841	11	
73855	600	
LG001	567	
65317	1	
68507	11	
73390	8	
73857	21	
73860	526	

D3286-3 Manufactured No 200 Each 101.0000 2 2

D3286-3******

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	101	
74117	21	
74439	80	

D2680-041 Manufactured No 210 Each 99.0000 1 1

D2680-041******

Nut Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	4	
73334	4	
ST020	95	
73854	95	

October-21-11 11:32:25 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

October-21-11 11:32:25 AM

Work Order ID: 75395

75395

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

2,010.000

2

2

CR3212-4-03******

Cherry Rivet

LocationLoc QtyLoc Code

FP-B

2

110139

2

ST311

1008

114859

1008

ST318

1000

119017

1000

AN960JD416

NAS1149D0463J

Purchased

No

210

Each

0.0000

1

1

AN960JD416******

Washer

CCR264SS3-3

Purchased

No

210

Each

1,285.000

2

2

CCR264SS3-3******

Cherry Rivet

LocationLoc QtyLoc Code

FP-B

2

113973

2

ST311

283

117849

283

ST317

1000

119017

1000

MS27039-4-06

Purchased

No

210

Each

433.0000

1

1

MS27039-4-06******

Screw

LocationLoc QtyLoc Code

ST292

433

119075

400

119124

33

October-21-11 11:32:25 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October-21-11 11:32:25 AM

Page 5

Work Order ID: 75395

75395

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No

270 Each 1,063.000 6 6

D2651-1

Plug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
fpa	2	
69018	2	
FP-A	1061	
57869	1	
66445	10	
70839	2	
71037	31	
73827	1017	

D2651-3 Manufactured No

270 Each 1,547.000 6 6

D2651-3

O-Ring

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP-A	1547	
61962	12	
66956	30	
73489	505	
73828	1000	

D3873-1 Manufactured No

280 Each 342.0000 14 14

D3873-1

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST088	342	
64760	1	
68247	4	
73829	19	
73831	318	

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 75395

75395

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

91.0000

1

1

D2646

Aft Cap

Location

Loc Qty

Loc Code

FP002

60

73294

60

FP004

17

68280

17

FP006

5

62678

5

FP-4

5

70945

1

71070

4

fp5

4

71038

4

D3805-041

Manufactured No

280

Each

0.0000

1

1

D3805-041

Wearplate Assembly Fwd, Low Gear

MS27039-1-08

Purchased No

280

Each

1,971.000

2

2

MS27039-1-08

Screw

Location

Loc Qty

Loc Code

ST291

1971

117423

155

118378

316

118910

500

119075

500

119109

500

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 7

October-21-11 11:32:25 AM

Work Order ID: 75395

75395

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

280

Each

9,976.000

7

7

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

976

117441

16

117885

87

118451

179

118927

694

ST516

6000

119017

6000

ST518

3000

119075

3000

D3805-045

Manufactured

No

280

Each

5.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

Location

Loc Qty

Loc Code

FP

5

73817

5

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

***AN960JD10L ***

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 8

October-21-11 11:32:25 AM

Work Order ID: 75395

75395

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No 280 Each 2,319.000 7 7

AN3-37A

Bolt

Location

Loc Qty

Loc Code

ST353

269

111668

169

118628

100

ST354

50

117619

50

ST518

2000

119086

2000

NAS1149D0363J Purchased No 280 Each 2,836.000 7 7

NAS1149D0363.J

Washer

Location

Loc Qty

Loc Code

ST298

2836

117601

218

118077

135

118612

483

118968

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75395 MCLJ
11/10/21

RELEASED
UP 09.03.03
per ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.07		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3804 REV. A
SHEET 1 OF 5

TITLE SKIDTUBE ASSEMBLY, 206A/B NTS

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

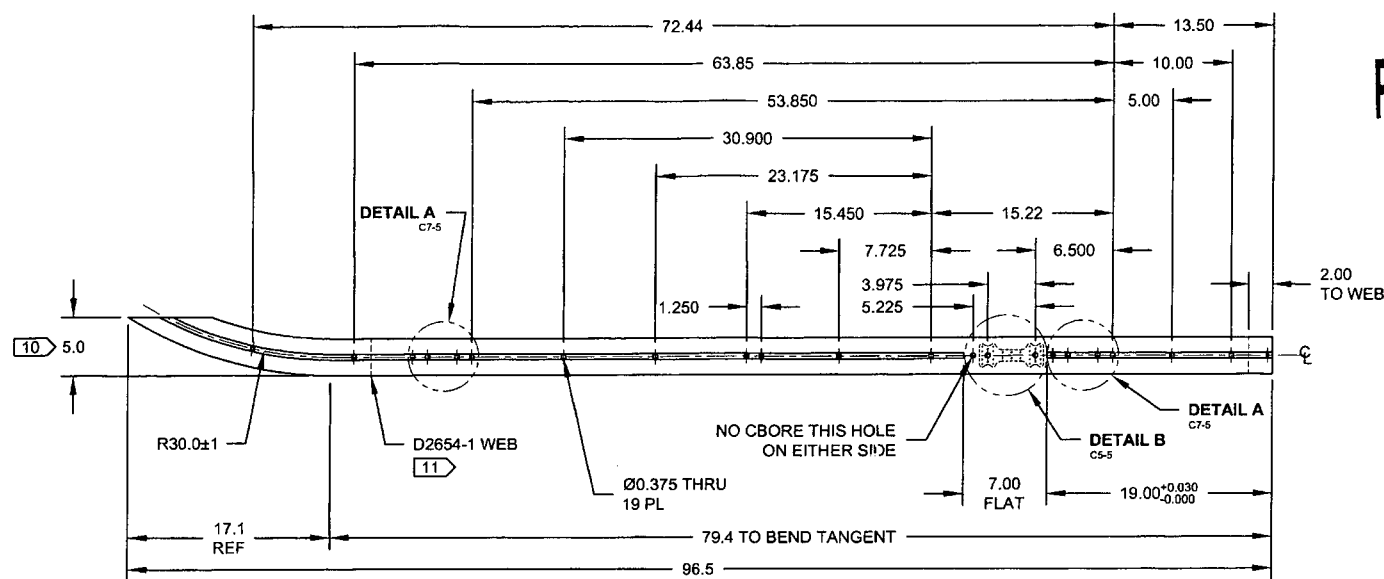
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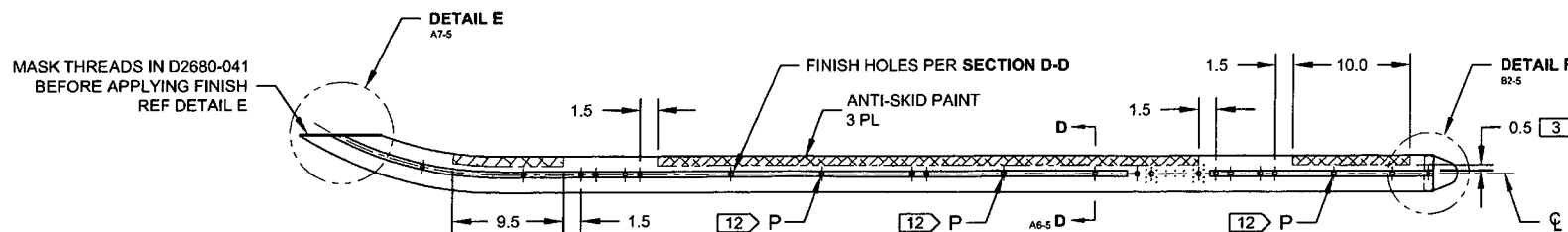
NOTE: Date & initial all entries

75395

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09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	9	DART AEROSPACE USA, INC	
DRAWN	9	PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	9	D3804	SHEET 2 OF 5
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DE APPR.	9	SKIDTUBE ASSEMBLY, 206A/B	NTS
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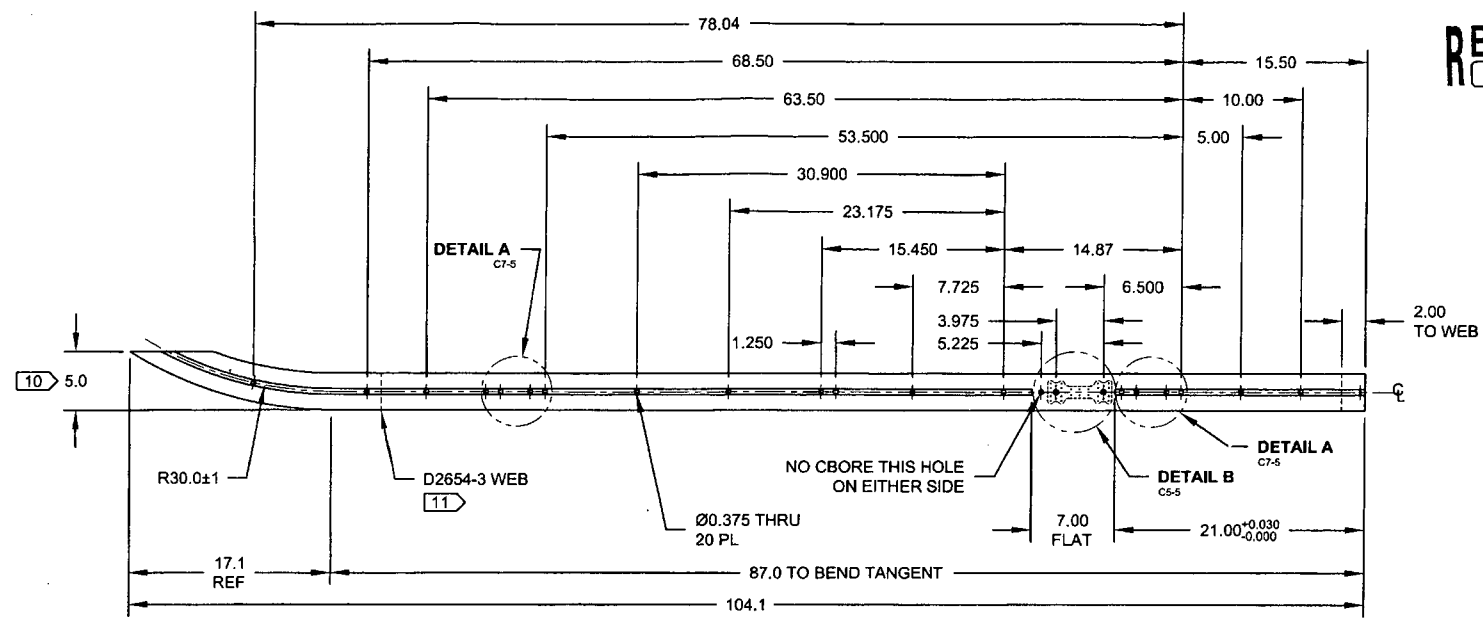
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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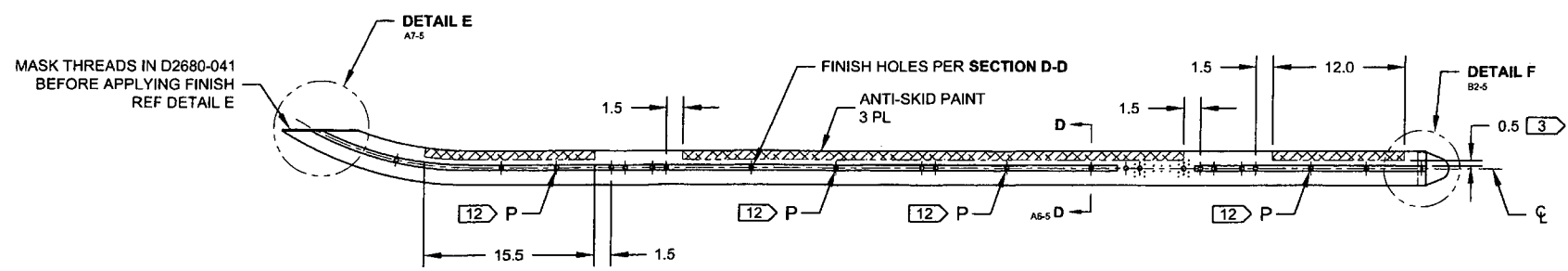
NOTE: Date & initial all entries

75395

RELEASED
(U 09.03.03)



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 3 OF 5
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DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

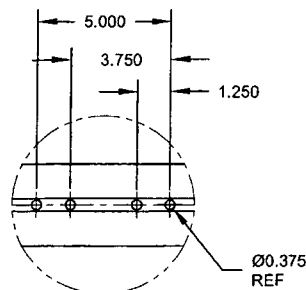
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

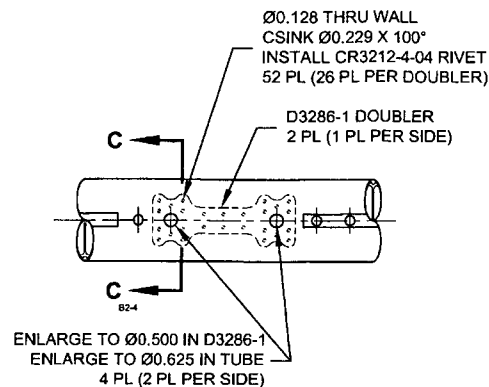
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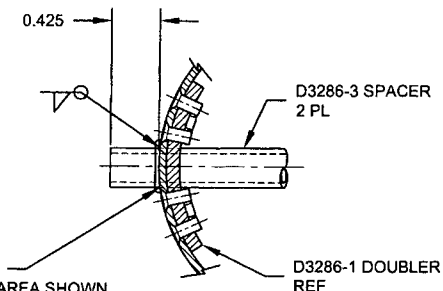
RELEASED
CP 09.03.07



DETAIL A
D6-2
C2-2
D6-3
C2-3
SCALE NONE

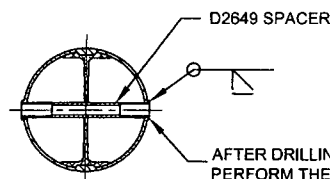


DETAIL B
C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
C6-4
PARTIAL SECTION
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	P	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 4 OF 5
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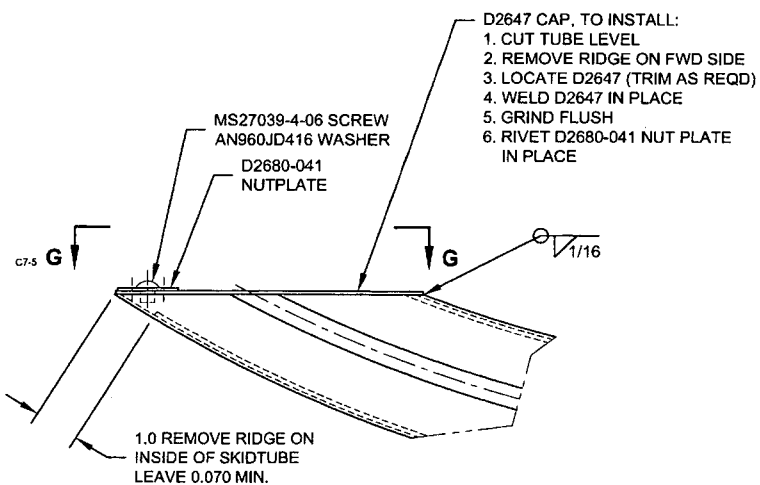
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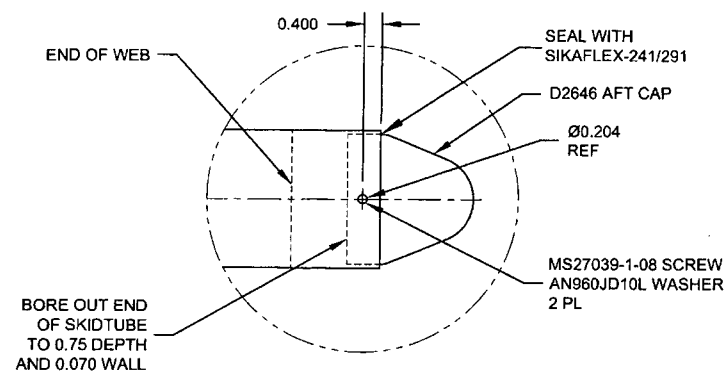
RELEASED
97 09.03.03

VIEW G-G
SCALE NONE

A7-5



DETAIL E
SCALE NONE

B7-2
B7-3

DETAIL F
SCALE NONE

B2-2
B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
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